

Date: Monday, 27/10/2008 7:49:13 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 42968		
Estimate Number	: 12487		
P.O. Number	:	Part Number	: D35021
This Issue	: 27/10/2008 S.O. No. :	Drawing Number	: D3502 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 41603	Material	:
Written By	: <u>08.10.27</u>	Due Date	: 03/11/2008 Qty: 30 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-07-06 JLM Est Rev:B Add tooling hole 07-03-28		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M8061T6B1000X04000	6061-T6 Bar 1.00 x 4.00
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Comment: Qty.: 0.3035 f(s)/Unit Total : 9.1035 f(s)

6061-T6 Bar 1.0" x 4.0"

batch: M107221

ml 08/10/27

(30)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 3.475" long

1 BLANK MAKES 2 PARTS

ml 08/10/27

(30)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA649 Rev: B & Dwg D3502 Rev: B

2-Deburr per dwg D3502

H.A

08/10/27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A

08/10/27

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

RG 08/10/28

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 42968

Part Number: D35021

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Drill as per Dwg D3502.

FF 08/11/03

(30)

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(30X)

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-1

08/11/03

8.0	POWDER COATING	POWDER COATING
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(30X)

M 109152

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:50
320 OF
1:20

M-1

08/11/03

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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44

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-03

(30X)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

ST 106

85 08/11/04 (30)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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08/11/05 44

Comment: FINAL INSPECTION/W/O RELEASE

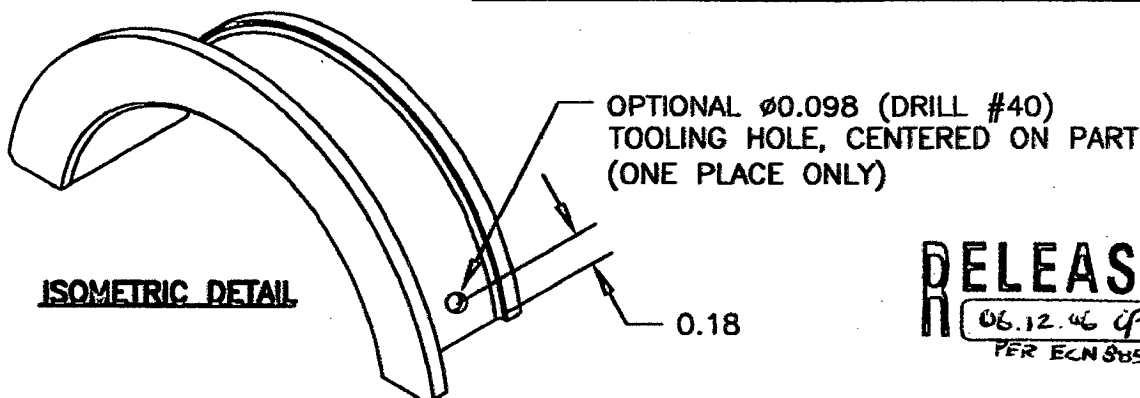
Job Completion



MF 08-11-04

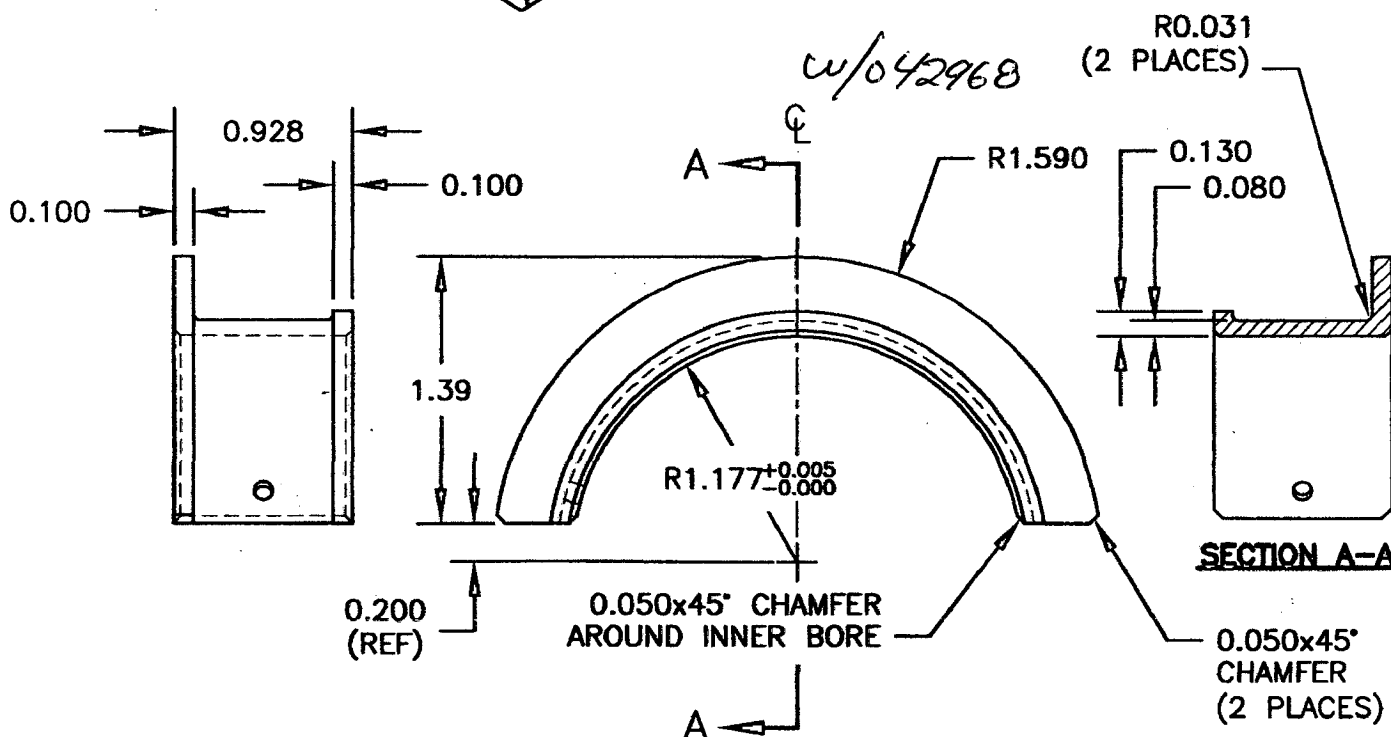


DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31	TITLE SUPPORT		SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	



ISOMETRIC DETAIL

RELEASED
06.12.06 *qp*
PER ECN 985



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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